

**Work Order ID 72146**

Tuesday, July 19, 2011 1:45:35 PM



Page 1

Item ID: D3407-5

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3407

Dwg Rev: E

Prog Rev: E

2-Break edges on grinder as per Dwg D3407

→ Ae 11.08.16

B11-8-3

68

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries



# Work Order ID 72146




Tuesday, July 19, 2011 1:45:35 PM



Page 2

Item ID: D3407-5 Accept  Setup Start   
Revision ID: Stop   
Item Name: Ring  
Start Date: 7/19/2011 Start Qty: 20.00  Cust Item ID:  
Required Date: 7/25/2011 Req'd Qty: 20.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		S wloc 17		counted (x28)			
130  Packaging Packaging	Identify as per dwg & Stock Location: W/A  Memo *****STOCK IN LARGE FAB*****	0.00  0.00				EL	11-8-17	(x28)	
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							W/8/18 11-08-17 (28)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries

*Tuesday, July 19, 2011 1:45:43 PM*

[illegible][illegible]**Required Date:** 7/25/2011

**Required Qty: 20.00**

**Comments:** IPP Rev:A New Issue 05-11-22 JLM  
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD  
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	13.5000	0.2666	5.612632	8.1		
 													
17-4 SS Bar .250 X 4.00													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT050			13.5						
				118243			13.5						
										118243			(28)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

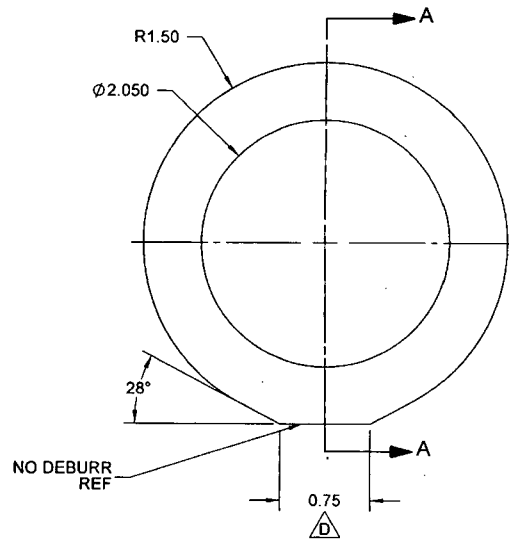
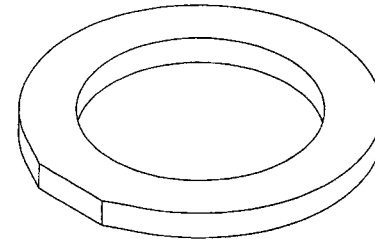
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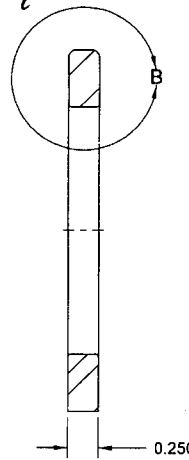


SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72146

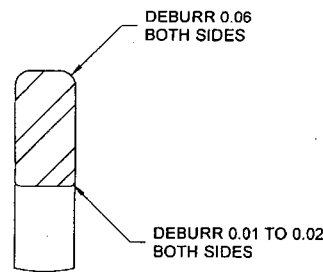
*11-07-19*



**D3407-5 RING**



**SECTION A-A**



**DETAIL B  
SCALE 2X**

**RELEASED**  
*08-06-01/19*

- NOTES:  
1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.27 lbs

DESIGN	<i>90</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>1/1</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3407</b>	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TOW RING</b>	NTS
DATE	<b>08.07.23</b>	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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